



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

D2597

Job Sheet 176669



Part No: D2597

Job Qty: 4 ea

Part Name: 204 Web



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/11/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E IPP: D 98.10.15 Eliminated DEO, Changed Dwg Revision KS IPP REV:E ADDED HOLES TO TOOLING 11-09-06 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Skid tubes		<i>DD 1.8</i>
100	Skid tubes	4 pcs	5/11/18	5/11/18	0.00	3.64	Skid tubes		<i>DD 2.3</i>
110	QC	4 pcs	5/11/18	5/11/18	0.00	0.00	QC5		<i>SY 3.6</i>
120	HandFinish	4 pcs	5/11/18	5/11/18	0.00	1.73	HandFinish1		<i>REP 18-05-09</i>
130	QC	4 pcs	5/11/18	5/11/18	0.00	0.00	QC7		<i>REP</i>
140	Packaging	4 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3-1		<i>Chap</i>
150	QC21-SA	4 Ea	5/11/18	5/11/18	0.00	0.00	QC21		<i>Chap 18/05/10</i>

Part Op 100 - Cut D2500-3 to length: 84.25" Use Jig DT9817 to drill pilot holes. Open to 0.625 diameter using a uni-bit.

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - Chemical Conversion Coat per QSI005 4.1

130 - QC7-Inspect Chemical Conversion Coat

140 - LOCATION : LG002

150 - QC21- Final Inspection - Work Order Release

DAS
21
9-80

MAY 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-3-100	Ext'n -I' Beam Web 4"	4 Ea (1 ea)	90-Start up Operation	<i>50 36056</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-3-100	4	39	0

Part Specifications

Specifications could not be found.

Plex 4/27/18 9:03 AM Dart.Gagnon.Michelle



Container No: S069752



Part: D2597

Job No: 176669

Serial No/Batch: S069752

Revision:

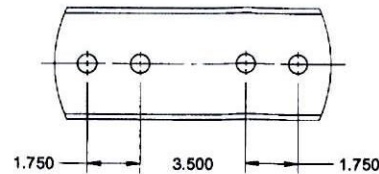
Inspector:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

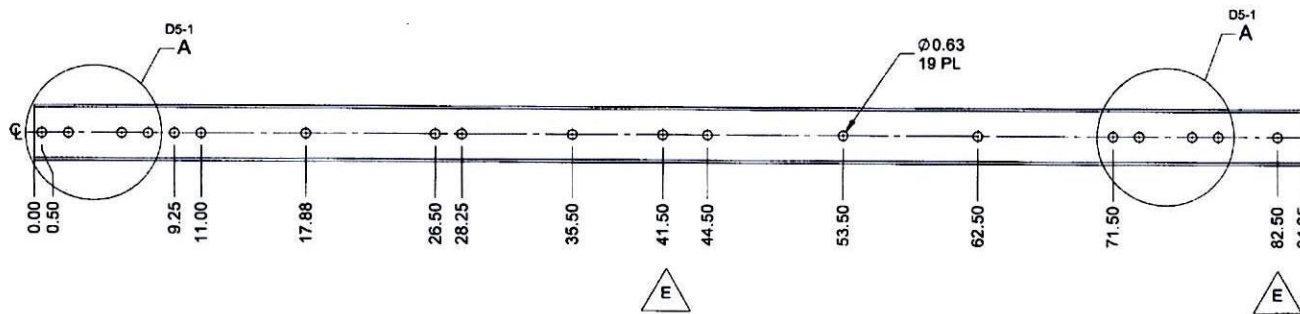
Date: 05/09/18

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 176669

MAY 03 2018



DETAIL A
 SCALE 2X
 C2-1
 C7-1



D2597 WEB (204)

RELEASED
 2011-08-29

NOTES:

- 1) MATERIAL: MANUFACTURED FROM D2500-3-84.25 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.99 lbs

E	ADD HOLES (ZN B5-1, B2-1)	RF	11.06.21
D	INCORPORATED DEO 9097	CP	98.09.14
C	Ø0.63 WAS Ø0.56	KE	97.07.23
B	5.75 WAS 0.50	DS	96.10.29
A	NEW ISSUE	DS	96.09.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	NO		
MFG. APPR.	DS		
APPROVED	NO		
DE APPR.	RF		
DATE	11.06.21		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2597	REV. E SHEET 1 OF 1
TITLE 204 WEB	SCALE NTS
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